ship Monday Feb 10 !

PRELIMINARY ISSUE

Work Order ID 112822

112822

February-07-14 11:54:03 AM

Item ID: D4541-8 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 2/07/14 **Start Qty:** 2.00 *2*

Required Date: 2/10/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ✓ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4541 / D									
100		0.00							
100						2	0		Ae 14.02.10
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1- Cut as per dwg(D4541-7f) Prog rev: P Dwg rev: D								
60601.032	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						2	0		Ae 14.02.10
QC	**Memo**	0.00							
Quality Control									

Prelim DXF

see attached marked up dwg !

Item ID: D4541-8 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket
Start Date: 2/07/14 **Start Qty:** 2.00 *2* **Cust Item ID:**
Required Date: 2/10/14 **Req'd Qty:** 2.00 *2* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 27 9-89				2			
120									
QC	**Memo**	0.00 14/2/10							
Quality Control									
130		0.00	DAS 30 9-89			2			14/02/10
130									
Small Fab	**Memo**	0.00							
Small Fab	Bend tabs as per dwg								
140	QC5- Inspect part completeness to step on W/O	DAS 0.00 27 9-89				2			
140									
QC	**Memo**	0.00 14/2/10							
Quality Control									

Work Order ID 112822

112822

February-07-14 11:54:03 AM

Item ID: D4541-8 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 2/07/14 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 2/10/14 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00				2	MG	14-2-10	
144 HandFinish Hand Finishing	**Memo**	0.00							
146	QC7-Inspect Chemical Conversion Coat	0.00 DAS 27 9-89				2			
146 QC Quality Control	**Memo**	0.00 4/2/10							
150	Identify as per dwg & Stock Location:_____	0.00	Shop Mat						
150 Packaging Packaging	**Memo**	0.00	14-2-12						

Work Order ID 112822

February-07-14 11:54:03 AM

112822

Item ID: D4541-8 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID:

Item Name: Bracket **Stop** *NS2*

Start Date: 2/07/14 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 2/10/14 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00				_____	11-02-10		
Quality Control									

WK 14-2-10

Picklist Print

February-07-14 11:54:02 AM

Work Order ID: 112822

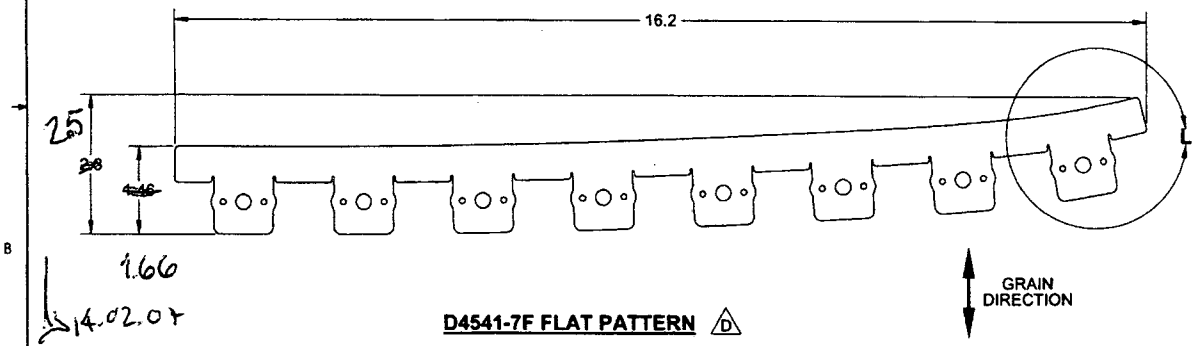
Parent Item: D4541-8 **Start Date:** 2/07/14 **Required Date:** 2/10/14

Parent Item Name: Bracket **Start Qty:** 2.00 **Required Qty:** 2.00

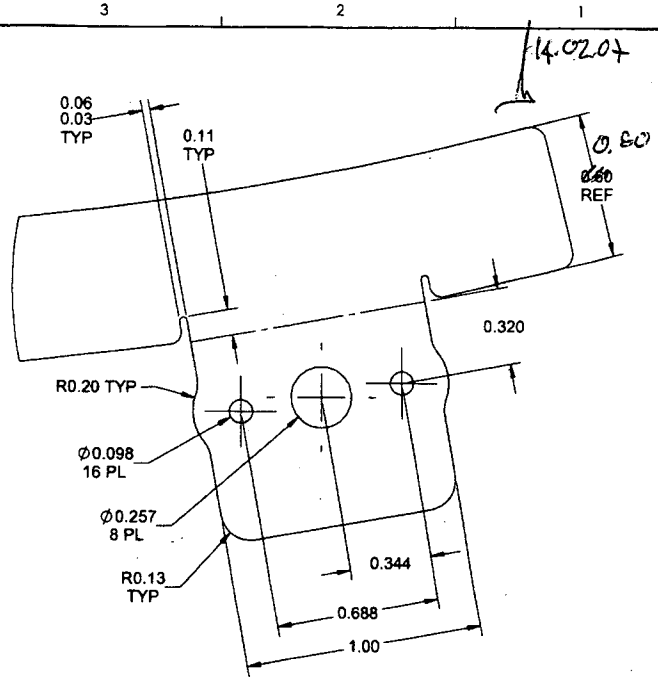
Comments: IPP REV:A 13.02.12 new issue DD verf:JLM IPP REV:B 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	473.3232	**0.258**	**1**	Ae 14.02.10		

Location	Loc Qty	Loc Code	
MAT021	473.32317		
123483	8.57		
m125822	17		
m127272	129.75317		
m128054	318		128054 → (1)



D4541-7F FLAT PATTERN (D)



DETAIL L
TYP TAB DETAIL
SCALE 4X

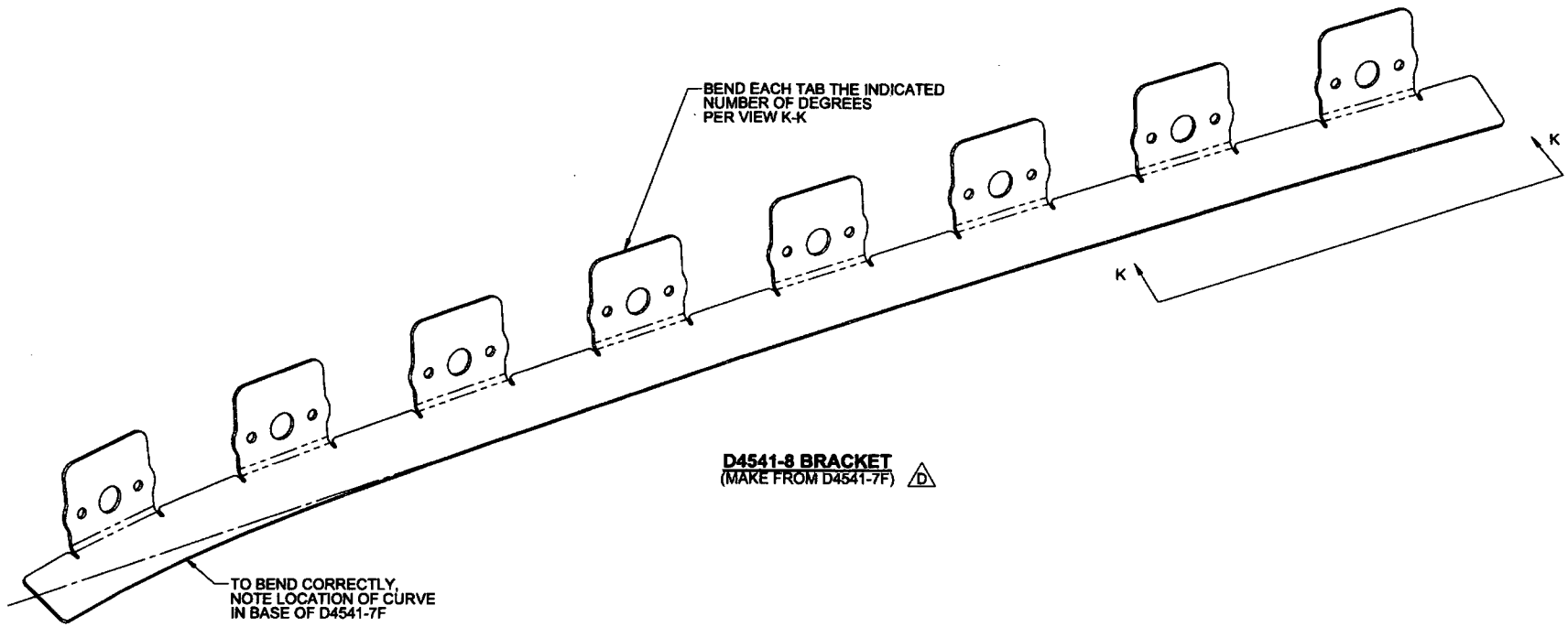
N2822
14.02.7

RELEASED
2013 -04- 22

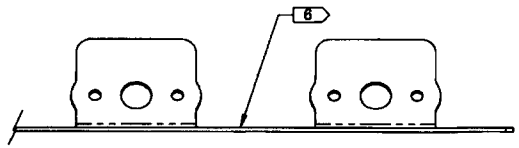
NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.04 lbs
8) PROFILE PER DRAWING FILE "D4541-7F-REVD.DXF"

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 REV. D
MFG. APPR.		SHEET 11 OF 11
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 13.02.04		

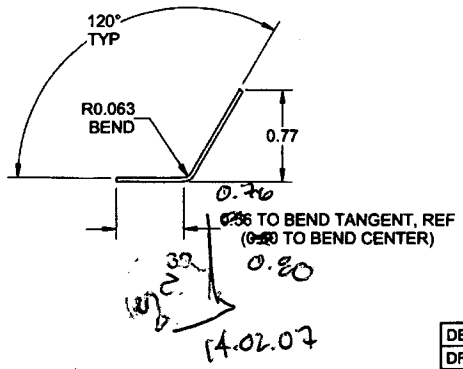
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D4541-8 BRACKET
(MAKE FROM D4541-7F) △D



VIEW K-K
BEND DETAIL
NOT TO SCALE



RELEASED
2013-04-22
MD

NOTES:
1) MATERIAL: MAKE FROM D4541-7F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D4541 — REV. D — SHEET 10 OF 11
CHECKED	ASS	TITLE BRACKET — SCALE NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE 13.02.04		

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Linda Lacelle

From: Marc Bellavance
Sent: February-07-14 11:50 AM
To: Linda Lacelle
Cc: Melanie Fauteux; Nigel Forbes
Subject: RE: Windshield Modification Kit Pn IIN-D206-817
Attachments: D4541-7F-REVD_CUSTOM.dxf

Sorry, DXF attached

From: Marc Bellavance
Sent: Friday, February 07, 2014 11:48 AM
To: Linda Lacelle
Cc: Melanie Fauteux; Nigel Forbes
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Thanks Linda.
DXF attached; I'll hand you the marked up dwg shortly.

From: Linda Lacelle
Sent: Friday, February 07, 2014 11:37 AM
To: Marc Bellavance
Cc: Melanie Fauteux; Nigel Forbes
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

We can sure try

From: Marc Bellavance
Sent: February-07-14 11:29 AM
To: Linda Lacelle
Cc: Melanie Fauteux; Nigel Forbes
Subject: FW: Windshield Modification Kit Pn IIN-D206-817

Linda,

Assisting Bell Helicopters installing our SIWK... They don't have enough meat on them parts and as per attached, ends up with very poor edge distance.

Can we get custom made D4541-7/-8, qty(2) each, out the door by Monday afternoon?
I can provide the DXF later this afternoon and will have to know the batch numbers for the no charge.

Marc

From: Boatright, Billy [mailto:bboatright@bh.com]
Sent: Thursday, February 06, 2014 4:24 PM
To: Marc Bellavance
Cc: Van Fleet, David; David Shepherd; Stelzig, Alan
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Hi Marc
We have some things to report as shown in the photos.
The pic of the retainer 4543-5 is one we received today, not enough room the screw head.
We haven't had time to see if the other retainers fit any better.

Will talk to you tomorrow .
Thanks

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt

423-538-5111 Fax 423-538-8469

bboatright@bh.com

Bell Helicopter
A Textron Company

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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Tuesday, February 04, 2014 9:44 AM
To: Boatright, Billy
Cc: Van Fleet, David; David Shepherd
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Bill,

The retainers are manufactured from 6061-T6 aluminum sheet, 0.032" thick.

Marc Bellavance
Technical / Shop Support

DART AEROSPACE
T 1 613 632 5200 > 243
M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com

Technical Publications: Verify Revision Status/Download **HERE**!

From: Boatright, Billy [mailto:bboatright@bh.com]
Sent: Tuesday, February 04, 2014 9:33 AM
To: Marc Bellavance; David Shepherd
Cc: Van Fleet, David
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Do you know what the final material is for the retainers ?
ie 7075 T3 ?

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt

423-538-5111 Fax 423-538-8469

bboatright@bh.com

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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Monday, February 03, 2014 4:39 PM
To: Boatright, Billy
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Thanks Bill.

Marc Bellavance
Technical / Shop Support

DART AEROSPACE
T 1 613 632 5200 > 243
M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com

DART AEROSPACE

Technical Publications: Verify Revision Status/Download **HERE**!

From: Boatright, Billy [mailto:bboatright@bh.com]
Sent: Monday, February 03, 2014 4:30 PM
To: Marc Bellavance
Subject: FW: Windshield Modification Kit Pn IIN-D206-817

FYI

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt

423-538-5111 Fax 423-538-8469

bboatright@bh.com

Bell Helicopter
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From: Boatright, Billy
Sent: Monday, February 03, 2014 4:27 PM
To: 'Peggy McDonald'
Cc: Van Fleet, David; Stelzig, Alan; David Shepherd
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

To all
So far we not had much luck with -6 retainer ,we will try -4 in AM.
It's too much shrink & expand in a short area.

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt

423-538-5111 Fax 423-538-8469

bboatright@bh.com

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From: Peggy McDonald [mailto:pmcdonald@dartaero.com]
Sent: Monday, February 03, 2014 8:42 AM
To: Boatright, Billy
Cc: Van Fleet, David; Stelzig, Alan; David Shepherd
Subject: RE: Windshield Modification Kit Pn IIN-D206-817
Importance: High

Good Morning Billy,

How does a call at 1:00 today work for you? I am located just outside of Mirabel, so I believe we are on the same time zone.

David Shepherd, our VP of Engineering, whom some of you may have met previously, will be on the call to provide technical support.

Once, I have your confirmation that this time is suitable, I will send an meeting request with call in numbers. We await your reply.

Kind regards
Peggy

Peggy McDonald
Sales Account Executive

DART AEROSPACE
T 1 613 632-3336 > 260
M 1 613 676-1710
F 1 613 632-4443
S pmcdonalddhs1
1 800 556-4166
www.dartaerospace.com

From: Boatright, Billy [mailto:bboatright@bh.com]
Sent: Friday, January 31, 2014 10:59 AM
To: Peggy McDonald

Cc: Van Fleet, David; Stelzig, Alan
Subject: Windshield Modification Kit Pn IIN-D206-817

Peggy

Attached are photos of one of the issues we talked about.
Things can wait until Monday for a conference call , we do have some time so maybe you will be able to send someone down to help us through the first one.

My Cell #423-502-5860
Dave Van Fleet # 423-213-0759

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt

423-538-5111 Fax 423-538-8469

bboatright@bh.com

Bell Helicopter
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DART AEROSPACE LTD	Work Order: 812 822
Description: BRACKET	Part Number: D4541-B
Inspection Dwg: D4541 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.5	+/- .030	2.5	-		V	
16.2	+/- .030	16.2	-		V	
1.66	+/- .030	1.65	-		V	
.80	+/- .030	.79	-		V	
.320	+/- .010	.320	-		V	
.344	+/- .010	.344	-		V	
.688	+/- .010	.688	-		V	
1.00	+/- .030	1.00	-		V	
.06	+/- .030	.05	-		V	
Ø .098	+.004/-.001	.100	-		V	
Ø .257	+.006/-.001	.260	-		V	
			DAS 27			

Measured by:		Audited by:	9-89	Preliminary Approval:	
Date:	14.02.10	Date:	14/2/10	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD

Description: Bracket		Work Order:	112822
Inspection Drawing: D4541	Rev: D	Part Number:	D4541-8

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.077	+/-.30	.772	✓		✓	SA-11
120°	+/-½	.120°	✓		Angle meter	SB 7
.76	+/-.030	.760	✓		✓	SA-4
.80	+/-.030	.802	✓		✓	SB-11

Measured by: DAS 30 9-89	Checked By: FF	QC inspector: DAS 27 9-89	Engineering Approval *(if necessary)*:
Date 14/02/10	Date 10-02-14	Date 14/2/10	Date